

Work Order ID 112702

112702

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Item ID: D139-799-013 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Cargo Door Fwd Opening Fits LH or RH
 Start Date: 2/06/14 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 2/27/14 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: W Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D139-799	H								
100	Document Control	0.00							
100									
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP D139-799-013 CHG006								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

DAS
06
9-89

APR 23 2014

DAS
33
9-89

1404-22

APR 23 2014

DAS
06
9-89

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Item ID: D139-799-013 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Cargo Door Fwd Opening Fits LH or RH
 Start Date: 2/06/14 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 2/27/14 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130						4	APR 24 2014		DAS 06 9-8
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D139-799-013 Location: <u>023</u> PPP rev: _____	0.00							
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

4 APR 24 2014

14/04/24

14-4-24

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Work Order ID: 112702

112702

Parent Item: D139-799-013

D139-799-013

Parent Item Name: Cargo Door Fwd Opening Fits LH or RH

Start Date: 2/06/14

Required Date: 2/27/14

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 10.06.08 new issue DD verf:JLM IPP REV:B
AS PER ECN 11-598 11-06-05 JLM VERIFIED BY:DD
IPP REV:C AS PER DSI9567 revA 11.10.17 DD VERF:EC IPP
REV:D 12.01.19 per iin rev.f ecn 12-507 DD verf:EC IPP REV:E
12.06.14 per ecn 12-606 DD verf:EC IPP REV:F 13.02.19
PER ECN13-507 DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4632-1		Manufactured	No			110	Each	11.0000	1	4			
---------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

D4632-1

Striker Plate

**

DAS
33
9-89

DAS
06
9-89

Location	Loc Qty	Loc Code
FG	2	
97450	2	
ST115	9	
112699	7	
114123	2	

DAS
33
9-89

D4632-2		Manufactured	No			110	Each	11.0000	4	4			
---------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

D4632-2

Striker Plate

**

DAS
33
9-89

14-04-22

Location	Loc Qty	Loc Code
FG	2	
97451	2	
ST115	9	
112700	7	
114124	2	

DAS
33
9-89

2x112700
2x114124

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Work Order ID: 112702

112702

Parent Item: D139-799-013

D139-799-013

Parent Item Name: Cargo Door Fwd Opening Fits LH or RH

Start Date: 2/06/14

Required Date: 2/27/14

Start Qty: 4.00

Required Qty: 4.00

MS21042L08

Purchased

No

110

Each

6,130.000

8

32

DAS

33

9-89

DAS

33

9-89

4 *MS21042L08*

Nut

DAS

06

9-89

Location

Loc Qty

Loc Code

ST314

3558

123900

58

m128401

1500

m128429

2000

ST508

2473

125445

1075

m127410

1398

ST509

99

m127304

99

125445

MS24694-S47

Purchased

No

110

Each

366.0000

8

32

DAS

33

9-89

DAS

33

9-89

4 *MS24694-S47*

SCREW

DAS

06

9-89

Location

Loc Qty

Loc Code

ST302

366

m128401

100

m128431

66

m128510

200

128431

MS27039-08-07

Purchased

No

110

Each

145.0000

8

32

DAS

33

9-89

DAS

33

9-89

4 *MS27039-08-07*

SCREW

DAS

06

9-89

Location

Loc Qty

Loc Code

ST307

145

122563

12

m128300

33

m128402

100

24 * 128300

8 * 128402

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Parent Item: D139-799-013

D139-799-013

Parent Item Name: Cargo Door Fwd Opening Fits LH or RH

Start Date: 2/06/14

Required Date: 2/27/14

Start Qty: 4.00

Required Qty: 4.00

NAS1149D0332J

Purchased

No

110

Each

5,786.000

12

64

DAS

33

9-89

NAS1149D0332.I

Washer

DAS

06

9-89

Location

Loc Qty

Loc Code

ST294

786

m128606

786

ST510a

5000

m128612

5000

128606

DAS

33

9-89

NAS1149DN832J

Purchased

No

110

Each

2,474.000

8

32

DAS

33

9-89

NAS1149DN832.I

Washer

DAS

06

9-89

Location

Loc Qty

Loc Code

MF4

880

M127255

880

ST293

1432

M127813

432

M128429

1000

st510

145

124555

145

ST510a

17

M126319

17

127813

DAS

33

9-89

D2585

Manufactured

No

110

Each

65.0000

14

4

DAS

33

9-89

D2585

Latch Clamp

DAS

06

9-89

Location

Loc Qty

Loc Code

ST012

65

108520

1

110344

3

112571

19

112974

14

114114

28

112571

DAS

33

9-89

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Work Order ID: 112702

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Parent Item: D139-799-013

D139-799-013

Parent Item Name: Cargo Door Fwd Opening Fits LH or RH

Start Date: 2/06/14

Required Date: 2/27/14

Start Qty: 4.00

Required Qty: 4.00

D2586

Manufactured No

110

Each

47.0000

4

**

DAS

33

9-89

114985

D2586

Door Latch

DAS

06

9-89

Location

Loc Qty

Loc Code

FG

13

100607

2

83893

10

95760

1

ST198A

34

108573

24

113641

10

D2621

Manufactured No

110

Each

48.0000

4

**

DAS

33

9-89

D2621

Latch Plate

9-89

Location

Loc Qty

Loc Code

FG

2

88616

2

ST013

46

108138

3

115195

43

D3552-23

Manufactured No

110

Each

35.0000

4

**

DAS

33

9-89

D3552-23

Door Prop

DAS

06

9-89

Location

Loc Qty

Loc Code

FG

6

101060

3

107728

2

83586

1

ST261

29

112982

8

113462

1

115158

20

115195

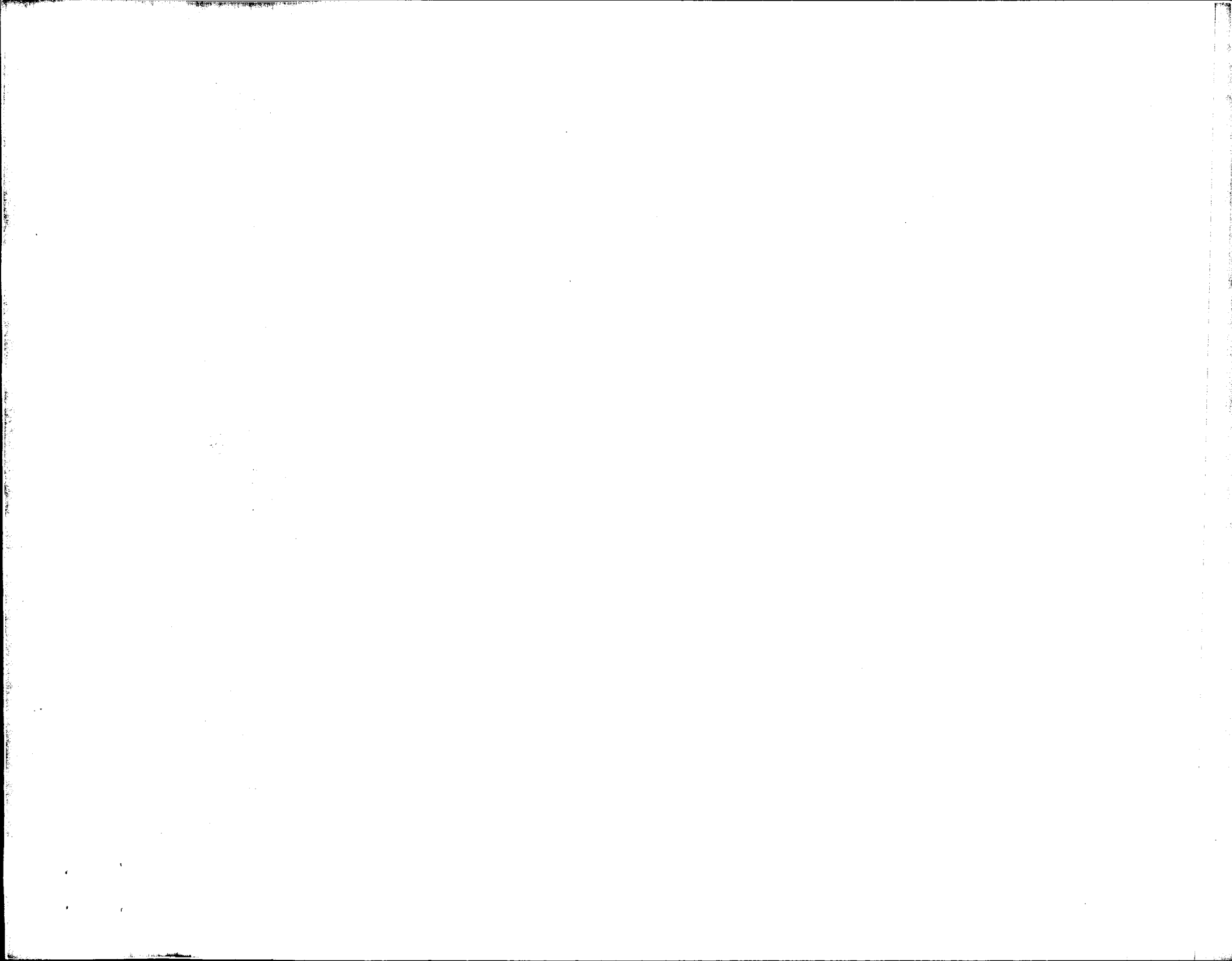
112982

14-04-22

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D139-799-013

Parent Item Name: Cargo Door Fwd Opening Fits LH or RH

Start Date: 2/06/14

Required Date: 2/27/14

Start Qty: 4.00

Required Qty: 4.00

D3622-1

Manufactured No

110

Each

28.0000

1 4

DAS
33
9-89

D3622-1

Ball Stud

DAS
03
9-89

Location

Loc Qty

Loc Code

ST058

28

112742

28

112741

DAS
31
9-89

D3622-3

Manufactured No

110

Each

28.0000

1 4

DAS
33
9-89

D3622-3

Ball Stud

DAS
03
9-89

Location

Loc Qty

Loc Code

ST058

28

108646

26

88383

2

108646

DAS
31
9-89

D4072-1

Manufactured No

110

Each

37.0000

2 8

DAS
33
9-89

D4072-1

Airframe Hinge

DAS
06
9-89

Location

Loc Qty

Loc Code

ST089

37

112692

3

113363

24

114115

10

113363

DAS
31
9-89

D4072-3

Manufactured No

110

Each

36.0000

2 8

DAS
33
9-89

D4072-3

Airframe Hinge Backing Plate

Location

Loc Qty

Loc Code

ST089

36

112693

10

114116

26

112693

DAS
31
14-04-20

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Work Order ID: 112702

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Parent Item: D139-799-013

D139-799-013

Parent Item Name: Cargo Door Fwd Opening Fits LH or RH

Start Date: 2/06/14

Required Date: 2/27/14

Start Qty: 4.00

Required Qty: 4.00

D4072-5

Manufactured No

110

Each

78.0000

4

16

**

DAS
33
9-89

DAS

D4072-5

Bushing

DAS
06
9-89

Location

Loc Qty

Loc Code

FG

5

105338

1

98569

4

ST089

73

112746

18

114117

55

112746

D4073-1

Manufactured No

110

Each

28.0000

2

8

**

DAS
33
9-89

DAS

D4073-1

Door Hinge
DAS
06
9-89

Location

Loc Qty

Loc Code

ST090

28

113187

20

114118

8

114118

D4073-3

Manufactured No

110

Each

36.0000

2

8

**

DAS
33
9-89

DAS

D4073-3

Door Hinge Backing Plate

DAS
06
9-89

Location

Loc Qty

Loc Code

ST089

36

112695

13

114119

23

112695

D4074-1

Manufactured No

110

Each

24.0000

1

4

**

DAS
33
9-89

DAS

D4074-1

Bracket
DAS
06
9-89

Location

Loc Qty

Loc Code

ST090

24

112696

4

114120

20

112696

14-04-27

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Parent Item: D139-799-013

D139-799-013

Parent Item Name: Cargo Door Fwd Opening Fits LH or RH

Start Date: 2/06/14

Required Date: 2/27/14

Start Qty: 4.00

Required Qty: 4.00

D4074-3
D4074-3
Channel

Manufactured No

110

Each

11.0000

1 4

**

DAS

33

9-89

DAS

31

9-89

DAS
06
9-89

Location

Loc Qty

Loc Code

ST090

11

108283

1

112697

6

114121

4

112697

D4074-5
D4074-5
Backing Plate

Manufactured No

110

Each

23.0000

4

**

DAS

33

9-89

DAS

31

9-89

DAS
06
9-89

Location

Loc Qty

Loc Code

ST090

23

74495

23

74495

D4074-7
D4074-7
Striker Plate

Manufactured No

110

Each

7.0000

4

**

DAS

33

9-89

14-04-22

DAS

31

9-89

DAS
06
9-89

Location

Loc Qty

Loc Code

FG

2

89406

2

ST090

5

112698

5

112698

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Parent Item: D139-799-013

D139-799-013

Parent Item Name: Cargo Door Fwd Opening Fits LH or RH

Start Date: 2/06/14

Required Date: 2/27/14

Start Qty: 4.00

Required Qty: 4.00

D4519-1

Manufactured No

110

Each

25.0000

4

DAS
33
9-89

D4519-1

Relay Bracket

**

DAS
06
9-89

Location

Loc Qty

Loc Code

FG

13

102694

5

99522

8

ST

3

89041

3

ST110

9

114122

9

114122

MS21042L3

Purchased

No

110

Each

8,568.000

32

144

DAS
33
9-89

MS21042L3

Nut

06
9-89

**

Location

Loc Qty

Loc Code

ST314

1613

M127410

572

M127831

41

M128401

1000

ST506

955

123900

955

ST509

6000

M128754

6000

127410

DAS
33
9-89

14-04-22

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Work Order ID: 112702

112702

Parent Item: D139-799-013

D139-799-013

Parent Item Name: Cargo Door Fwd Opening Fits LH or RH

Start Date: 2/06/14

Required Date: 2/27/14

Start Qty: 4.00

Required Qty: 4.00

MS21042L5

Purchased

No

110

Each

1,599.000

4

MS21042L5

Nut

**

DAS
33
9-89

14-04-22

DAS
06
9-89

Location

Loc Qty

Loc Code

GA

5

117611

5

ST315

94

m127304

94

ST509

1500

m127813

500

m128810

1000

127304

DAS
31
9-89

MS27039-1-10

Purchased

No

110

Each

913.0000

32

MS27039-1-10

SCREW

**

DAS
33
9-89

14-04-16

DAS
06
9-89

Location

Loc Qty

Loc Code

ST305

122

m126474

1

m128401

121

ST506

600

m128635

600

st507

191

m127993

191

127993

DAS
31
9-89

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Work Order ID: 112702

112702

Parent Item: D139-799-013

D139-799-013

Parent Item Name: Cargo Door Fwd Opening Fits LH or RH

Start Date: 2/06/14

Required Date: 2/27/14

Start Qty: 4.00

Required Qty: 4.00

MS27039-1-14

Purchased

No

110

Each

989.0000

2

8

MS27039-1-14

Screw

DAS
06
9-89

Location

Loc Qty

Loc Code

GA

98

120449

98

ST506

262

124326

262

st507

629

124326

629

**

DAS

33

9-89

DAS
31
9-89

MS27039-1-16

Purchased

No

110

Each

283.0000

8

32

MS27039-1-16

Screw

DAS
06
9-89

Location

Loc Qty

Loc Code

ST306

283

125654

1

m128402

82

m128409

200

**

DAS

22

9-89

DAS
31
9-89

MS27039-1-17

Purchased

No

110

Each

422.0000

13

4

MS27039-1-17

Screw (601.1954)

DAS
06
9-89

Location

Loc Qty

Loc Code

GA

50

120142

50

ST306

222

124326

72

m127305

150

ST506

150

m127831

150

**

DAS

33

9-89

DAS
31
9-89

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Work Order ID: 112702

112702

Parent Item: D139-799-013

D139-799-013

Parent Item Name: Cargo Door Fwd Opening Fits LH or RH

Start Date: 2/06/14

Required Date: 2/27/14

Start Qty: 4.00

Required Qty: 4.00

NAS1149D0363J

Purchased

No

110

Each

5,169.000

18 72

NAS1149D0363.I

Washer

DAS
06
9-89

**

DAS

33

9-89

Location

Loc Qty

Loc Code

GA

23

124392

23

ST510a

5146

m126319

130

m127813

16

m128429

5000

58X126319

427813

14X128429

DAS

33

9-89

NAS1149D0663J

Purchased

No

110

Each

2,401.000

1 4

NAS1149D0663.I

Washer

DAS
06
9-89

**

DAS

33

9-89

Location

Loc Qty

Loc Code

ST294

7

123265

4

M126284

3

ST510a

2394

M126334

699

M127813

35

M127916

660

M128818

1000

127916

NAS1515H5L

Purchased

No

110

Each

141.0000

4 16

*NAS1515H5I *

Washer

DAS
06
9-89

**

DAS

33

9-89

14-04-16

Location

Loc Qty

Loc Code

FG

40

103691

40

ST297

101

125621

101

125621

DAS

33

9-89

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Work Order ID: 112702

112702

Parent Item: D139-799-013

D139-799-013

Parent Item Name: Cargo Door Fwd Opening Fits LH or RH

Start Date: 2/06/14

Required Date: 2/27/14

Start Qty: 4.00

Required Qty: 4.00

IN4007
IN4007

DIODE
DAS
06
9-89

Purchased No

110 Each

106.0000

4

DAS
33
9-89

**

Location

Loc Qty

Loc Code

FG	5	
120363	5	
ST285	101	
m126551	1	
m128443	100	

128443

M12883/41-19

Purchased No

110 Each

43.0000

4

DAS
33
9-89

**

M12883/41-19
RELAY BASE

DAS
06
9-89

Location

Loc Qty

Loc Code

FG	16	
122097	1	
125289	15	
ST286	27	
m128122	1	
m128442	6	
m128545	20	

128442

M39029/92-534

Purchased No

110 Each

145.0000

4 16

DAS
33
9-89

**

M39029/92-534
SOCKET CONTACT

DAS
DAS
06
9-89

Location

Loc Qty

Loc Code

FG	70	
120363	20	
125289	50	
ST287	75	
m128276	50	
m128301	25	

128276

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Work Order ID: 112702

112702

Parent Item: D139-799-013

D139-799-013

Parent Item Name: Cargo Door Fwd Opening Fits LH or RH

Start Date: 2/06/14

Required Date: 2/27/14

Start Qty: 4.00

Required Qty: 4.00

M83536/9-024M

Purchased

No

110

Each

46.0000

4

M83536/9-024M

RELAY

DAS
03
9-89

Location

Loc Qty

Loc Code

FG

20

124916

20

ST287

4

m128121

4

ST390

22

m128548

22

**

DAS
33
9-89

D4761-1

Manufactured

No

110

Each

18.0000

4

D4761-1

Shim Block

DAS
03
9-89

Location

Loc Qty

Loc Code

ST122

18

114125

18

**

DAS
33
9-89

AN507-1032R12

MS24693-S274

Purchased

No

110

Each

100.0000

16

AN507-1032R12

Screw

DAS
06
9-89

8ac #2

Location

Loc Qty

Loc Code

ST351

100

M128429

100

**

DAS
33
9-89

AN507-1032R15

Purchased

No

110

Each

81.0000

16

AN507-1032R15

Screw

DAS
06
9-89

Location

Loc Qty

Loc Code

ST344

81

m128429

81

**

DAS
33
9-89

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Qty -013	Part Number	Description
X	D139-799-013	CARGO DOOR HINGE KIT
1	D2585	MOUNTING CHANNEL
1	D2586	DOOR LATCH
1	D2621	LATCH PLATE
1	D3552-23	DOOR PROP
1	D3622-1	BALL STUD
1	D3622-3	BALL STUD
2	D4072-1	AIRFRAME HINGE
2	D4072-3	AIRFRAME HINGE BACKING PLATE
4	D4072-5	BUSHING
2	D4073-1	DOOR HINGE
2	D4073-3	DOOR HINGE BACKING PLATE
1	D4074-1	BRACKET
1	D4074-3	CHANNEL
1	D4074-5	BACKING PLATE
1	D4074-7	STRIKER PLATE
1	D4519-1	RELAY BRACKET
1	D4632-1	STRIKER PLATE
1	D4632-2	STRIKER PLATE
1	D4761-1	SHIM BLOCK
1	IN4007	DIODE
4	AN507-1032R12	SCREW
4	AN507-1032R15	SCREW
1	M12883-41-19	RELAY BASE
4	M39029/92-534	SOCKET CONTACT
1	M83536/9-024M	RELAY
8	MS21042L08	NUT (or MS21042-08)
32	MS21042L3	NUT (or MS21042-3)
1	MS21042L5	NUT (or MS21042-5)
8	MS24694-S47	SCREW
8	MS27039-0807	SCREW
8	MS27039-1-10	SCREW
2	MS27039-1-14	SCREW
8	MS27039-1-16	SCREW
1	MS27039-1-17	SCREW
18	NAS1149D0363J	WASHER (or AN960JD10)
1	NAS1149D0663J	WASHER (or AN960JD616)
12	NAS1149D0332J	WASHER (or AN960JD10L)
8	NAS1149DN832J	WASHER (or AN960JD8)
4	NAS1515H-5L	WASHER

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Revision: H

Date: 13.06.11

Work Order ID 112702

February-05-14 11:21:54 AM

112702

Page 1

Item ID: D139-799-013

Accept

N900040100

Setup

Start

NS1

Revision ID:

Stop

NS2

Item Name: Cargo Door Fwd Opening Fits LH or RH

Start Date: 06/02/2014 Start Qty: 5.00

5

Cust Item ID:

Required Date: 27/02/2014 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals:

Process Plan: 

Date: 14-02-05

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

IIN-D139-799


H

100

0.00

100

DC

Memo 

0.00

Document Control

Photocopy bluefile & type labels per PPP D139-799-013
CHG006

ML5 14-03-05



110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

4x DAS 28 14-03-5
9-09

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control